

Work Order ID 162001***162001***

Page 1

Tuesday, May 23, 2017 11:06:48 AM

Item ID: D3552-23

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Prop

Start Date: 6/1/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/8/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: MAY 24 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3552	L

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

36474

Purchase Part Number: B6-190-475-070N

Supplier: LS Technologies

Certificate of conformity is required

6

MAY 29 2017

DAS
13
9-89

110

0.00

110

Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.12

Packaging

Ensure certificate of conformity is attached

6x SP17-531

120

0.00

120

QC6- All purchased or subcontracted products

QC

Memo

0.00

Quality Control

Test for correct pressure

6

DAS
38
9-89
JUN 12 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Work Order ID 162001

Tuesday, May 23, 2017 11:06:48 AM

162001

Page 2

Item ID: D3552-23 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Prop
Start Date: 6/1/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 6/8/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: ST363	0.00							
130						6		DAS 6 9-89	
Packaging	Memo	0.06							
Packaging								JUN 14 2017	
140	QC21- Final Inspection - Work Order Release	0.00							
140						DAS 21 9-89		JUN 12 2017	
QC	Memo	0.60							
Quality Control								DAS 21 9-89	JUN 12 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

Tuesday, May 23, 2017 11:06:47 AM

Page 1

Work Order ID: 162001

162001

Parent Item: D3552-23

D3552-23

Parent Item Name: Door Prop

Start Date: 6/1/2017

Required Date: 6/8/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 11.04.07 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B6-190-475-070N		Purchased	No			100	Each	0.0000	1	6			
R6-190-475-070N									**				
Door Prop													

Cox 5/23/17-5-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

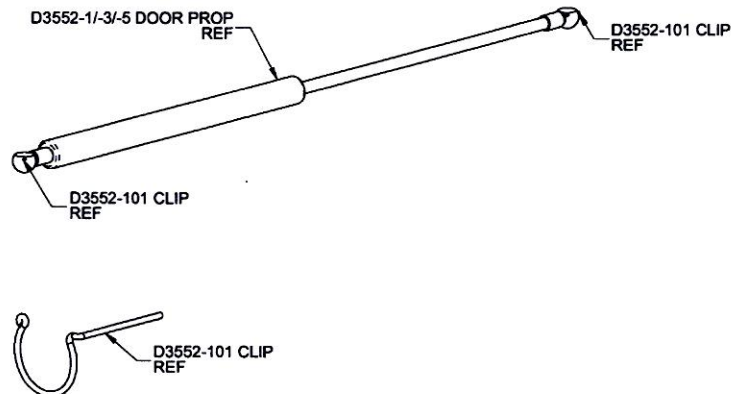
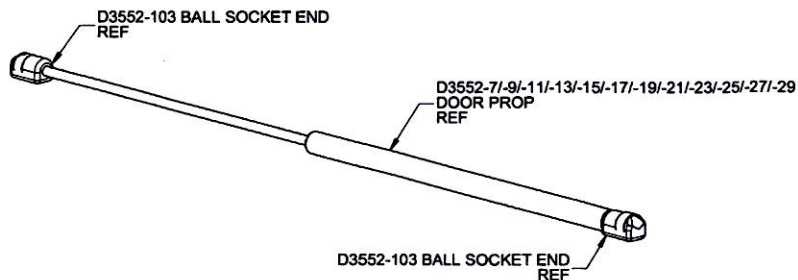
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

SPECIFICATION CONTROL DRAWING



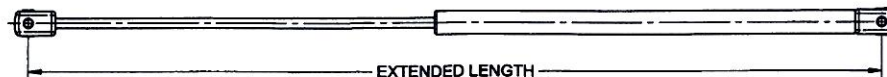
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162001 *MCS*
170524

RELEASED
2015-08-04
ECN 15-609

L	ADD P/N D3552-29	VS	15.04.13
K	ADD "X" TO LS TECHNOLOGIES P/Ns TO DESIGNATE "EXTRA DAMPING" FOR D3552-15/-17/-19/-23/-27. REASON: PAR12-209.	MB	12.07.16
J	ADD P/N D3552-25/-27. REMOVE ALTERNATE PART NUMBER FOR -15, -17 AND -19. STROKE FOR -15, -17 AND -19 WAS 139/6.06 NOW 154/6.06. EXTENDED LENGTH FOR -15, -17 AND -19 WAS 388/15.2 NOW 387/15.2.	AP	11.12.07
I	ADD P/N D3552-23	RF	11.10.11
H	ADD P/N D3552-21	DC	11.03.10
G	FOR -15, FORCE:300/87.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 139/5.47 WAS 160/6.30, EXT LG: 388/15.2 WAS 407/16.0, SUPPLIER P/N B8-154-387-156N WAS B8-167-408-156N	JPH	10.11.01
F	ADD P/N D3552-15/-17/-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	LE	07.06.01
B	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
REV.	DESCRIPTION	BY	DATE

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	AK	DRAWING NO.	REV. L
MFG. APPR.	DD	D3552	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DOOR PROP	NTS
DATE	15.04.13	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-140N
D3552-15	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300NX
D3552-17	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-156NX
D3552-19	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060NX
D3552-21	DOOR PROP	167/6.57	410/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-167-410-070N
D3552-23	DOOR PROP	190/7.48	475/18.7	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-190-475-070N
D3552-25	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-300NX
D3552-27	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-156NX
D3552-29	DOOR PROP	190/7.48	475/18.7	100/22.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-190-475-100N
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10

D3552-X DOOR PROP

RELEASED
2015-08-04

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	AK	DRAWING NO.	REV. L
MFG. APPR.	DD	D3552	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DOOR PROP	NTS
DATE	15.04.13	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) IDENTIFICATION: IDENTIFY PER QSI 044 6.2
- 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS
- 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11/-13/-15/-17/-19/-21/-23/-25/-27/-29 DOOR PROPS



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36474**

Purchase Order Date 5/29/2017

PO Print Date 5/29/2017

Page Number 1 of 2

Order From :

VC-LST0001

Ship To : DART AEROSPACE LTD

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Contact Name

Vendor Phone 306 683 5000

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	BS104 AS PER DWG D3554-7 REV. A B162143	BALL STUD	5/30/2017 Yes 5/30/2017		10.00 Each	\$1.55	\$15.50
Line Total:							\$15.50
2	6/15-164/50-115N AS PER DWG D2807-041 REV. E B161721	Gas Spring	6/2/2017 Yes 5/5/2017		6.00 Each	\$63.90	\$383.40
Line Total:							\$383.40
3	B6-190-475-070N AS PER DWG D3552-23 REV. L B162001	Door Prop	6/2/2017 Yes 5/5/2017		6.00 Each	\$32.50	\$195.00

DAG
38
9-89

SP17-5-31

PO Instructions: Fedex Acc#151793240

Note:

5/29/2017

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

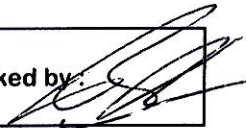
P.O. No.	Date	Invoice #
36474	5/29/2017	16684

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
5/29/2017	Fed-Ex	

Qty	Description
10	BS104 - D3554-7 B162143 10mm Ball Stud Zinc 5/16-18 Thd .75" Lg
6	D2807-041 B161721 Stainless Gas Spring
6	D3552-23 B162001 Gas Spring
Shipping Via FEDEX Tracking # 779248220515	
SP17-5-31	

Order checked by: 

DAS
38
9-89



LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Conformance

May 29, 2017

This is to certify that the parts listed below meets specifications as required by your order.

10 Units : BS104 - D3554-7 B162143 10mm Ball Stud Zinc 5/16-18 Thd .75" Lg

6 Units : D2807-041 B161721 Stainless Gas Spring

 **6 Units : D3552-23 B162001 Gas Spring**

Country of Manufacture : Canada

Date of Manufacture : May 2017

This product is ROHS compliant.

Purchase Order # 36474

Inv# 16684

L S Technologies Inc Canada



Nolan Fehr
President